

Work Order ID 124829

September-24-14 9:19:11 AM

shp to store for sth
124829

Page 1

Item ID: D3186-4 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacepod Door, RH
 Start Date: 9/24/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/10/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3186	Rev E								

100 0.00
100
 Small Fab
 Small Fab
 Small Fab

Small Fab

Memo

1-Trim door to fit spacepod before drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

110 0.00

110

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

120 0.00

120

Packaging

Packaging

Identify as per dwg & Stock Location: *1-6126*

Memo

stock as is (for ERA)

u 14-11-06

14/11/16 sep

Work Order ID 124829

124829

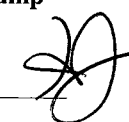
Page 2

September-24-14 9:19:11 AM

Item ID: D3186-4 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Spacepod Door, RH
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

14/11/6 

MF
14-11-06

Picklist Print

September-24-14 9:19:11 AM

Page 1

Work Order ID: 124829

124829

Parent Item: D3186-4

D3186-4

Parent Item Name: Spacepod Door, RH

Start Date: 9/24/14

Required Date: 10/10/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 07-01-11 EC

IPP rev.B revD 07.03.07 ec

IPP Rev:C

10-08-11 added trim door before drilling DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3186-2M

Manufactured

No

100

Each

0.0000

1

1

D3186-2M

Spacepod Door RH

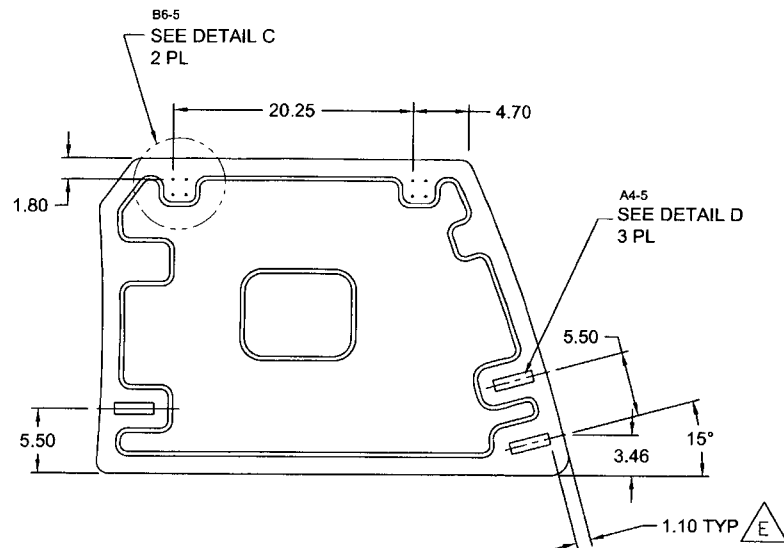
124829

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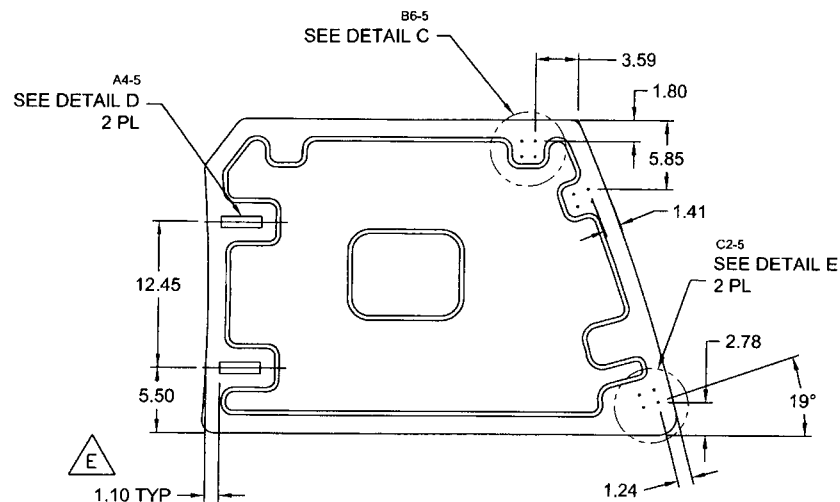
RT 14-11-06

2P

8 7 6 5 4 3 2 1



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

W/O 124829

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

C

B

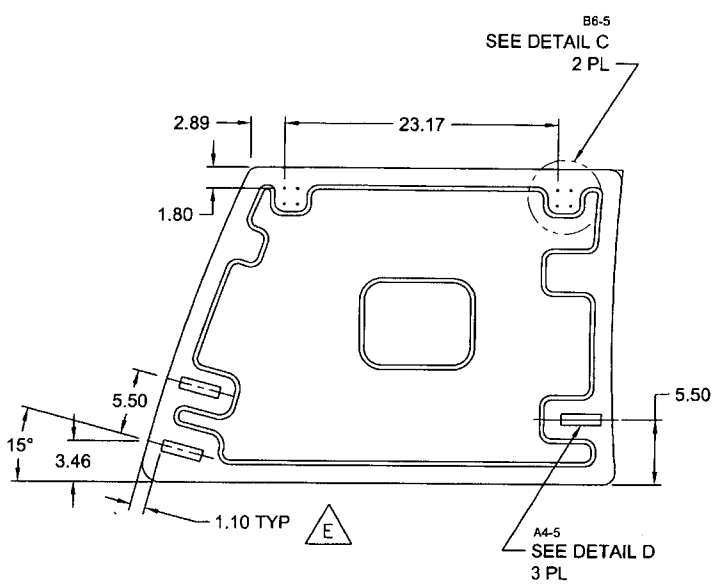
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D

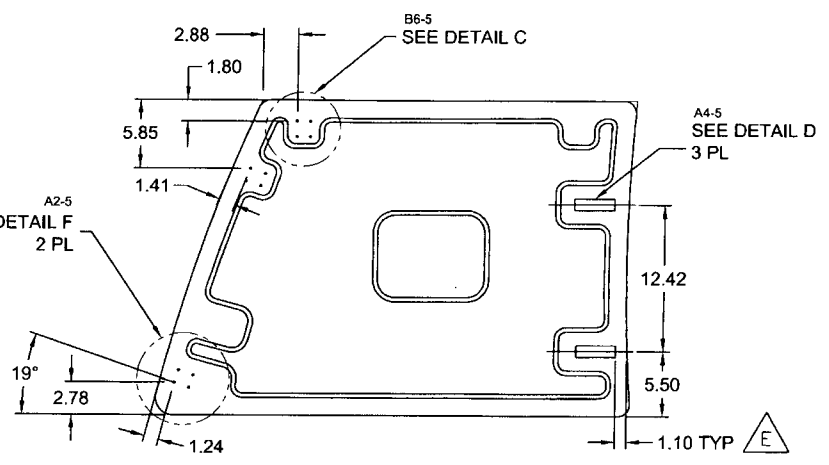
C

B

A



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

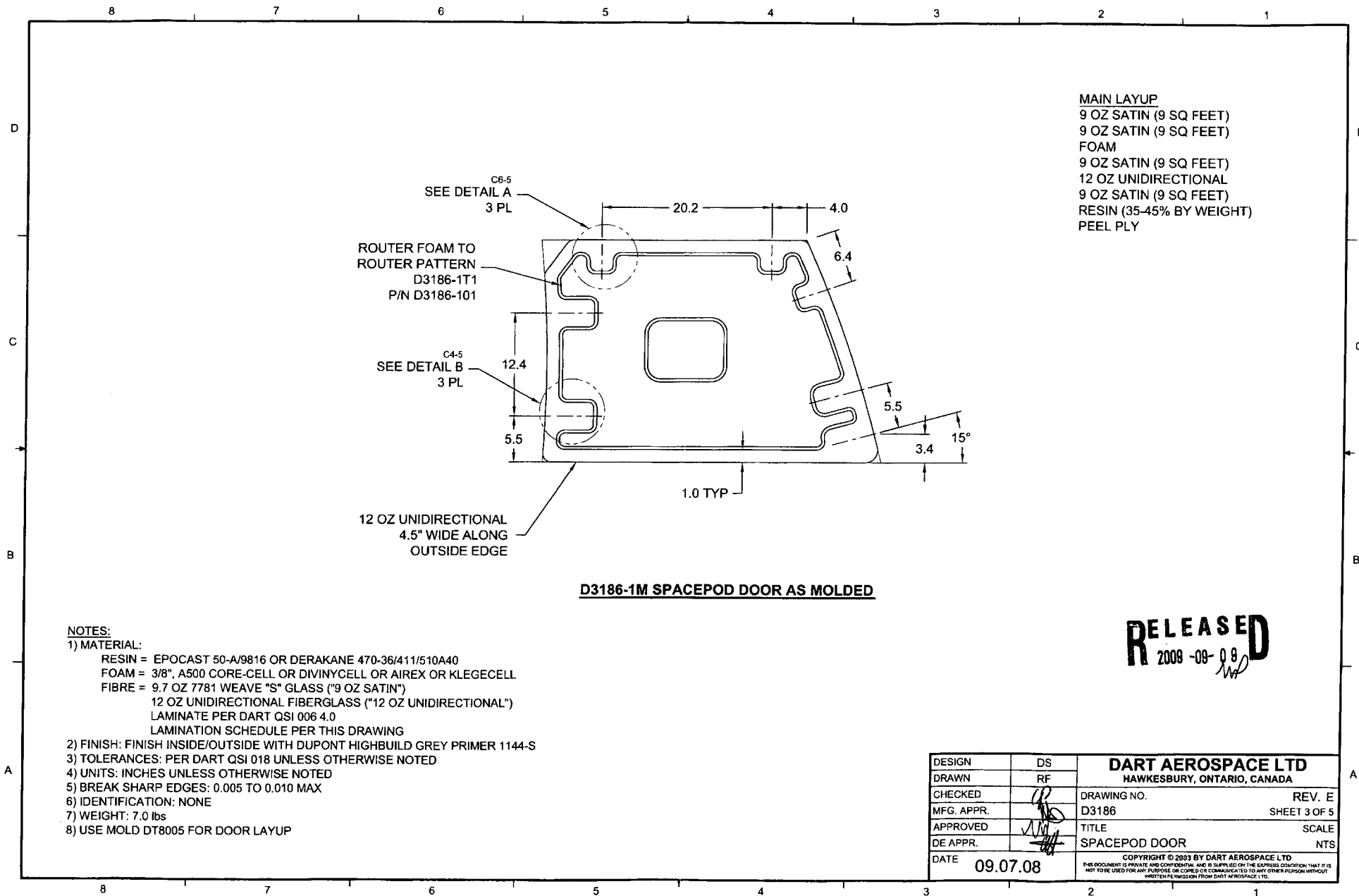
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2009-09-09

NOTES:

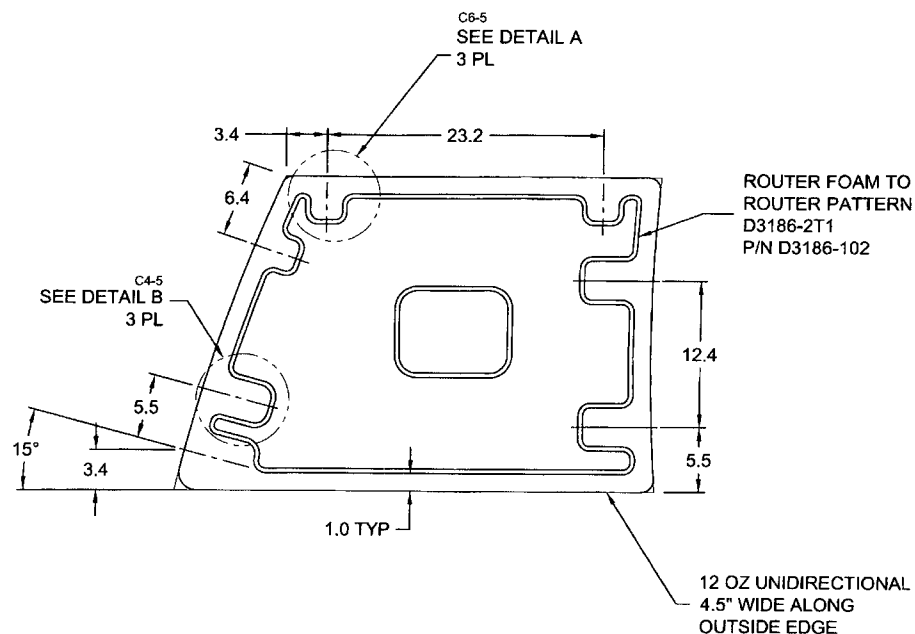
- 1) MATERIAL: N/A
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- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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DRAWN	RF		
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MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 2 OF 5
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8 7 6 5 4 3 2 1



9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



NOTES:
1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8". A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECCELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING

- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8006 FOR DOOR LAYUP

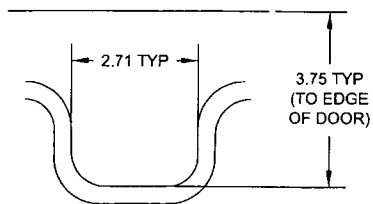
D3186-2M SPACEPOD DOOR AS MOLDED

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2009-09-09

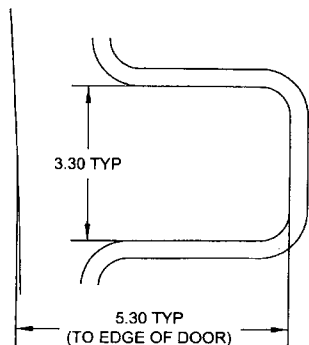
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. I
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NT
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8 7 6 5 4 3 2 1

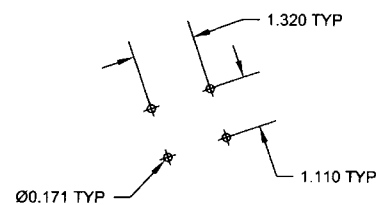
D
C
B
A



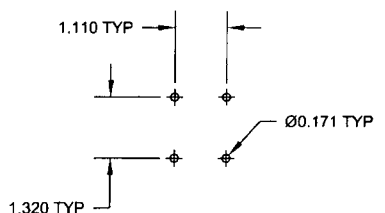
DETAIL A D6-3
SCALE 4X D4-4



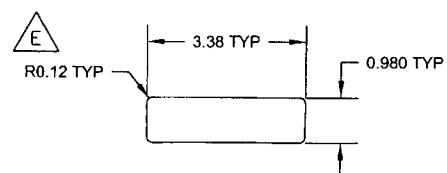
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

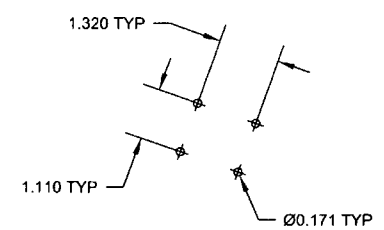


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2







NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

RELEASED
2009-08-09

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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
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8 7 6 5 4 3 2 1